PRODUCT INSTRUCTIONS

RELOADING DIE

WARNING:

• Do not attempt to make a pressed case or go into cavity (overflared cases). Excessive pressure can result in serious injury or death.
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• This product is designed for your specific cartridge impressed on the case. Do not use cases or components for another cartridge.
• Do not overflare (bell) straight-wall cases. Excessive flaring can cause case to be distorted or even burst.
• Do not clean cases with chemicals other than those specifically designed for cleaning. Use only those recommended for cleaning.
• Observe good housekeeping in the reloading area. Keep tools and equipment in a clean, orderly condition.
• Do not smoke while reloading, or reload near sources of heat, sparks or flames.
• For lead cast bullet loading, periodically disassemble and clean the Expander plug and Bushing.

LIFETIME LIMITED WARRANTY

Any warranty implied by law, such as the warranty of merchantability or fitness for a particular purpose, is limited to the duration of this express warranty. Some states do not allow limitations on how long a warranty lasts, so this limitation may not apply to you. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

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Read and follow these precautions before attempting to
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Customer Service
1-800-833-0335 (U.S. or Canada)
rcbs.tech@rcbs.com

RCBS
605 Oro Dam Blvd East
Oroville, CA 95965

rcbs.com

PACKAGING

A piece of lead shot under the setscrew may prevent accidental stripping. Once the die has been adjusted, tighten the setscrew to hold the proper setting. The die will then hold the proper setting and may be reused in the same condition.

PREPARING THE DIES

When a die has been stripped (fully open) lightly tighten the screw to hold the proper setting. All RCBS dies feature a steel Lock Ring with a hex design that allows tight adjustments of the die setting. These rings are made of stainless steel. A piece of lead shot under the setscrew may prevent accidental stripping. Once the die has been adjusted, tighten the setscrew to hold the proper setting. The die will then hold the proper setting and may be reused in the same condition.

REPLACEMENT PARTS

Parts may not apply to you. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

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Cases must be properly lubricated before sizing. Over-lubrication will result in an RCBS Case Lube Pad or Case Slick® Spray Lube. Case mouths resist as the Shell Holder contacts the bottom of the die. The handle of the press frame. Return the handle to the lowest position and you will feel the shell holder, and set the die one-eighth to one-quarter of a turn lower into position (handle all the way down), screw the Sizer Die into the press until halfway up the die body (solid brass barrel), and set the lock ring. Tighten the lock ring. Loosen the Expander Plug Lock Ring and unscrew the Expander Die body down into the press until it is just above the Shell Holder, as it will distort or crush the case.

THREE-DIE SET FOR STRAIGHT-WALL RIFLE AND PISTOL CASES

To prevent damage to the Expander Die, make sure the Expander Die is just above the Shell Holder. If the Expander Die is not above the Shell Holder, the Expander will not lift the case from the Shell Holder because it is too close to the die body. The case will be damaged if the Expander Die is too high above the Shell Holder. The Expander Plug, however, must be just below the Shell Holder in order to prevent damage to the case. To center the Expander Plug, you may need to use the Expander Plug Lock Ring and unscrew the Expander Plug from the Expander Die.

SETUP

BCI Carbide Sizer Die shown on shell. The case is seated in the Carbide Sizer Die on the right.

SHOTS WITH TRIM SIZES OF 7.5-µm (.0003"") OR LESS

If the lock ring is not properly adjusted, the bullet may not be seated or crimped properly. The bullet should be seated and crimped if it is not set deeply enough. You should be able to screw the bullet into the case. If the bullet is not set deeply enough, the bullet may not be seated or crimped properly. The bullet should be seated and crimped if it is not set deeply enough. You should be able to screw the bullet into the case.

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SIZING WITH CARBIDE SIZER DIES

With the correct Shell Holder in the press ram and the ram at its uppermost position, move the ram to the lower position. That resistance is the tapered portion of the Expander contacting the case. Set the Expander Plug Lock Ring only when reloading magnum cases. This will give the most accurate crimp setting for magnum cases.

A Tungsten Carbide Sizer Die will give you a lifetime of perfect service if properly cared for. However, the case will not withstand severe impact damage. Several manufacturers produce Tungsten Carbide dies, carbide tools, and carbide parts. The objective is to expand and flatten the case mouth to receive the bullet, and the third die seats and, if necessary, crimps the bullet fully into the Seater Die. Check the bullet for proper crimping. The case is sized (full length, neck or small base), decapped, and expanded through the reloading steps.